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THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION: MIL-F-85421.

MALE FITTING ENDS PER MIL-F-85421/1, STYLE 2 SEALING SURFACE (ACROSS FLATS) (REF) PORT 2 PORTI BEAM SEAL CHICK ON CH D (REF) IDENTIFICATION LOCATION HFX FEMALE FITTING END TO MATE WITH MIL-F-85421/1 STYLE I OR STYLE 2 **REVISED 2002-03** THIRD ANGLE PROJECTION ISSNED PROCUREMENT SPECIFICATION: AS85421 PREPARED BY SAE COMMITTEE G-3

The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL

AEROSPACE STANDARD

FITTING, TEE, REDUCER AND NON-REDUCER, BEAM SEAL, 3000/4000 PSI, MALE ON RUN, SWIVEL NUT ON BRANCH

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Port	Port	Port (3)	А	В	С	D (Ref)	E (Ref)	F		G Rad (Min)	Wt Lbs (Max) Ti Cres	
04	04	04	.684	.684	.808	1.014	.500	.562		.042		
04	04	06	.684	.684	.945	1.178	.500	.688		.042	.058	.102
06	06	04	.704	.704	.808	1.014	.500	.562		.042	.063	.110
06	06	06	.704	.704	.945	1.178	.500	.688		.042		
06	06	80	.811	.811	1.045	1.294	.562	.875		.070	.103	.183
06	06	10	.878	.878	1.178	1.485	.688	1.000	+.003	.070	.116	.204
06	04	80	.811	.791	1.045	1.294	.562	.875	004	.070	3 098	.173
08	04	06	.824	.791	.945	1.178	.562	.688		070	.097	.172
08	08	80	.824	.824	1.045	1.294	.562	.875	85	.070		
10	10	10	.955	.955	1.178	1.485	.875	1.000	82	.098		
12	12	10	1.062	1.062	1.178	1.485	.875	1.000		.098	.226	.409
12	12	12	1.062	1.062	1.316	1.659	.876	1.125		.098		
16	10	10	1.246	1.158	1.275	1.582	1.125	1.000	+.016	.098	.204	.360

REQUIREMENTS:

See procurement
specification Titanium Alloy Materials: Corrosion Resistant Steel

Finish: Titanium: Fluoride phosphate coat per AMS 2486. Corrosion Resistant Steel: Surface shall be treated and 2.

passivated per QQ-P-35.

NOTES:

- Dimensions are in inches. Unless otherwise specified, tolerances are: decimals +.015.
- Remove all burrs and break all sharp edges.
- All machined surfaces shall be smooth to 125 microinches $R_{\rm a}$ per ANSI/ASME B46.1 unless otherwise specified.

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